

Date: Wednesday, 25/06/2008 10:02:04 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	UPPER RESTRAINT WELDMENT
Job Number :	40064		
Estimate Number :	13398		
P.O. Number :		Part Number :	PB674300131
This Issue :	25/06/2008	Drawing Number :	B6743001 P.41/ P.43
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	//	Drawing Revision :	B1
Previous Run :		Material :	
Written By :		Due Date :	04/07/2008
Checked & Approved By :	<u>JUL 08. 6.25</u>	Qty:	5 Um: Each
Comment :	Est Rev:A 08-06-20 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S090	6061-T6 .090 Sheet
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Comment: Qty.: 0.4557 sf(s)/Unit Total : 2.2785 sf(s)
 6061-T6 .090 Sheet
 batch: 108595 B 8-7-15

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg B67-43001 - 321 08.06.25
 Dwg Rev: B1 B 8-7-15
 Prog Rev: B1
 ***grain direction along 25.00" ***
 2-Deburr if necessary B 8-7-15

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 Bend as per Dwg B67-43001

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02 07/16 (46)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.3

Handwritten: 08/07/16 (60)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME: 7:10 AM

OVEN TEMPERATURE: 320°F

FINISH TIME: 7:40 AM

Handwritten: 08-07-17 (46)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: 08-07-17 (6)

10.0

PB674300133

Upper Pad Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Upper Pad Assembly

batch: 40064

Handwritten: 08-08-26

11.0

NAS1149F0316P

WASHER



Comment: Qty.: 5.0000 Each(s)/Unit Total: 25.0000 Each(s)

WASHER

batch: 10870

Handwritten: 08-08-26

12.0

MS27039109

Screw



Comment: Qty.: 5.0000 Each(s)/Unit Total: 25.0000 Each(s)

Screw

batch: 18057

Handwritten: 08-08-26

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Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1- Assemble as per dwg B67-43001

08.08.26 5

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/26/08

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

08/26/08

16.0

QC21

FINAL INSPECT

RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/26

Job Completion



08/08/26

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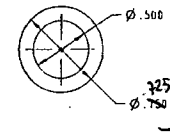
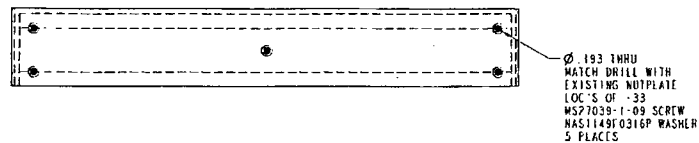
QA: N/C Closed: _____ Date: _____

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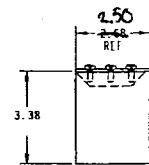
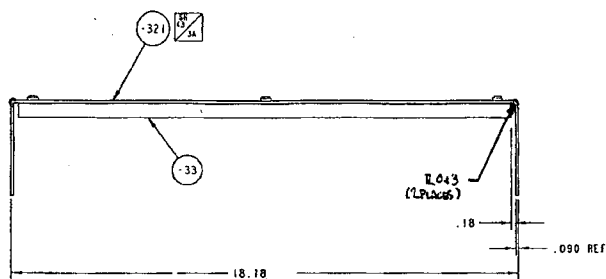
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 4000

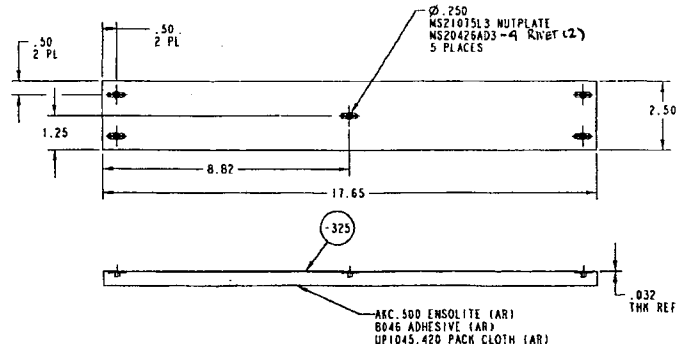
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6.01.70



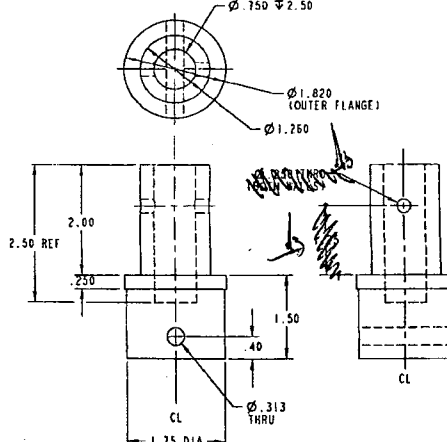
① -299 BUSHING
SCALE 2.000
MAT: 304 CRES, COND A



① -31 UPPER RESTRAINT WELDMENT
SCALE 0.500



① -33 UPPER PAD ASSY
SCALE 0.500
MATL FOR -325: .032 THK 2024-T3 AL.
OO-A-250/4



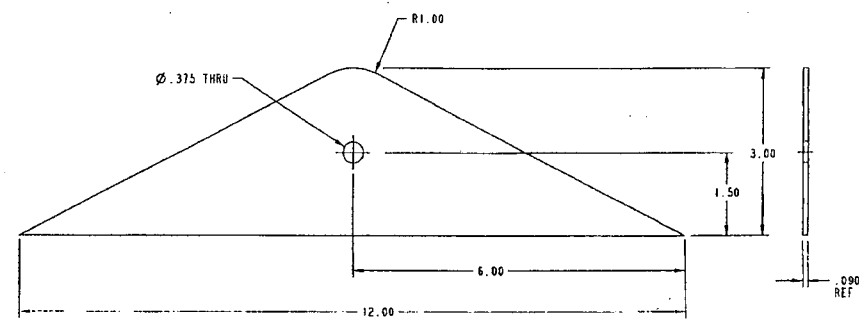
① 305 BEARING
SCALE 1.000
MAT: 2024-T3 AL.
OO-A-206/3

PREMIER AVIATION, INC.
2021 Aviation Parkway, Grand Prairie, Texas 75052
D10SUV8 B67-43001
SCALE: 1:1 WT: 1.000
SHEET 41 OF 45

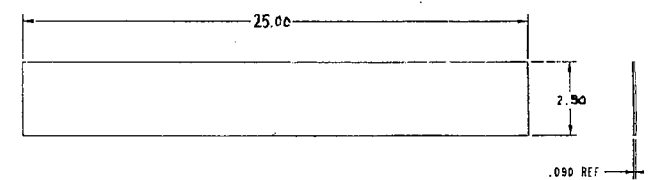
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SHOP COPY
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40004

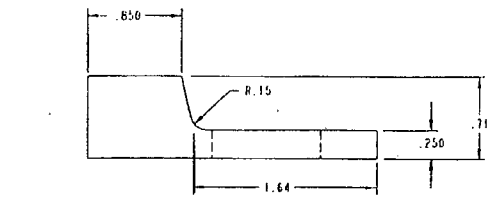
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26 JUL 20



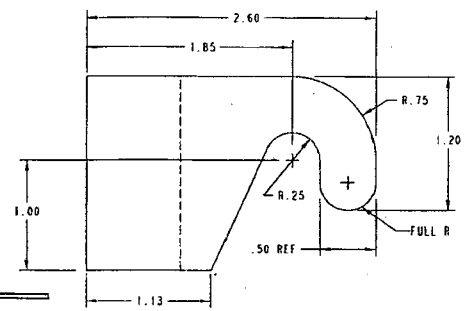
② -319 GUSSET
SCALE: 1.000
MAT: .090 THK 6061-T6 AL.
QQ-A-200/8



① -321 PLATE
SCALE: 0.500
MAT: .090 THK 6061-T6 AL.
QQ-A-200/8

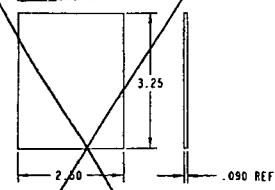


③ -315 HOOK
SCALE: 2.000
MAT: 6061-T6 AL.
QQ-A-200/8

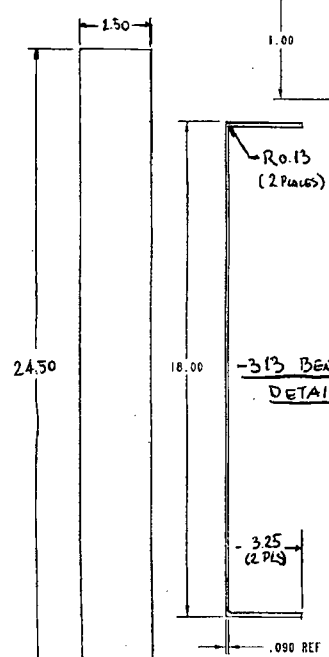


-313 BENDING
DETAIL

SUPERCEDED BY
NEW PART OF -313



② -317 PLATE
SCALE: 0.750
MAT: .090 THK 6061-T6 AL.
QQ-A-200/8



① -313 FLAT PATTERN
SCALE: 0.500
MAT: .090 THK 6061-T6 AL.
QQ-A-200/8

PREMIER AVIATION, INC.
5001 Aviation Parkway, Grand Prairie, Texas 75052
SIZE: 11x17 CONF: 100 PT NO: 000 00
D: 050V8 B67-43001
SCALE: 1:1 DT: 1 SHEET: 43 OF 45

ORIGINAL

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